

Work Order ID 137387

137387

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Friday, September 25, 2015 1:03:06 PM

Item ID: D5046-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head
 Start Date: 9/25/2015 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 9/30/2015 Req'd Qty: 15.00 ***15*** Customer:
 Reference: SCRAP

Approvals: Process Plan: MF Date: 15-9-25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D5046	B								

180 0.00
180
 QC 0.00
 Quality Control
 Memo
 PULL FROM STOCK D5046-1 X 15:
 8 X B117555
 7 X B117705
 SCRAP PER ECN15-577

(15) 1603-15-11

190 0.00
190
 Small Fab 0.00
 Small Fab
 Memo
 SCRAP

(15) DAS 38 9-89

MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Item ID: D5046-1 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Co-Pilot Collective Head
Start Date: 9/25/2015 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 9/30/2015 Req'd Qty: 15.00 ***15*** Customer:
Reference: SCRAP

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

MCS MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Work Order ID: 137387

137387

Parent Item: D5046-1

D5046-1

Parent Item Name: Co-Pilot Collective Head

Start Date: 9/25/2015

Required Date: 9/30/2015

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV. A NEW ISSUE JFS 14/04/11 VERIFIED BY:DD
IPP REV. B MAT'L SIZE HAS CHANGED AS PER REV.B JFS 15/09/23
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5046-1

Manufactured

No

Each

0.0000

15

D5046-1

Co-Pilot Collective Head

8 x 117555 y mf
7 x 117705 15-9-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								OTHER :																																							

List Lots

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Criteria : Item ID: D5046-1 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
D5046-1 Co-Pilot Collective Head	Main Warehouse WA002	117555	5/22/2014	8.0000		QC21	
	Main Warehouse WA002	117705	5/22/2014	7.0000		QC21	
Total:				15.0000			

137387

Rev. A
Rework? No
scrap

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date:	15.06.29	Job No.:		ADR Yes/No:	N	ADR Date:		ECN #:	15- 577
Product No.:	D212-803			Created By:	VS	Approved By:	<i>[Signature]</i>		
Product Name:	LH PIC			Checked By:	<i>[Signature]</i>				

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	<i>[Signature]</i> 15/6/02
Production Manager / Coord.	Y	MP / MF	<i>[Signature]</i> 15.7.2
Purchasing Manager / Purchasing Coord.	N	LL / CL	
Production Engineering Coord.	Y	DD / JLM	<i>[Signature]</i> 15.07.02
Production Engineering Coord.	N	DL	
Customer Order Processing	N	SL / BG	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS / ED	<i>[Signature]</i> 15/07/02
QC Coordinator	Y	PD	<i>[Signature]</i> 15.07.02
Customer Support	Y	SW / LM	<i>[Signature]</i> 15.07.02
Customer Technical Support	Y	MB / HS	<i>[Signature]</i> 15.07.02
Marketing	Y	KO / SL	<i>[Signature]</i> 15.09.06
Sales Support Manager	Y	CP	<i>[Signature]</i> 15.7.02

Reason for Change:
Small updates to drawings

Documents Affected:
D4410 Rev. E, D5046 Rev. B, D5155 Rev. B, D5156 Rev. B, DSI 9728 Rev. A

IF APPLICABLE: NCR: _____ PAR: _____ CAR: 14-92 CIR: _____ URF: 15-577

PAPERWORK UPDATE ☒ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	Y	VS	URF 15-577	<i>[Signature]</i> 15.05.21 VS
6	Update Master Document List (MDL)	N		Next Update	
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		<i>[Signature]</i> 15.07.03
12	Update Product Specification Files (Bluefiles)	Y	KJ		<i>[Signature]</i> 15.07.02
13	Update Approved/Preliminary Dwg PDF Files.	Y	KJ	Add DSI 9728 Rev. A	<i>[Signature]</i> 15.07.02
14	Update Product Development Summary (STC applications)	N			<i>[Signature]</i> 15.07.02
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		<i>[Signature]</i> 15.07.02
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ		<i>[Signature]</i> 15.07.02
18	Create / Update Change Record Form / Item Card Database	Y	KJ	For DXXX-803-0XX/-1XX Kits	<i>[Signature]</i> 15.07.02
19	Create / Update Packaging Process Plan (PPP)	Y	KJ		<i>[Signature]</i> 15.07.02
20	Red Decals required on Packaging Process Plan (PPP)?	Y	KJ		<i>[Signature]</i> 15.07.02
21	Update Controlled Supplier Documents (Qpulse) Database	N			<i>[Signature]</i> 15.07.02
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		<i>[Signature]</i> 15.07.02
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ		<i>[Signature]</i> 15.07.02
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			<i>[Signature]</i> 15.07.02
25					

Description / Action:

- Add MS171539/MS171599 Pins to D205-803/D212-803 kits per page 3 of DSI 9728
- Add DSI 9728 to kit paperwork
- Update routings to reflect latest drawing revisions
- Update BOM for D212-803/D205-803 kits to include MS171539/MS171599 Pins

DXXX-803-011/-013/-015/-017/-019 @ CHG003

DXXX-803-111/-113/-115/-117/-119 @ CHG002

ECN Verified & Complete: *[Signature]* Date: JUL 13 2015